

Date: Thursday, 10/11/2007 2:51:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 35111 <i>7</i>	Part Number	: D3469043
Estimate Number	: 12183	Drawing Number	: D3469 REV A1
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 10/11/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Due Date	: 10/25/2007
Previous Run	: 28556	Qty:	4 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 07.10.11		
Comment	: Est Rev: A New Issue 06-02-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34691	TUBE
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3469-1	Tube	<i>B35141</i>

[Signature]

mf

2.0	D34695	LOWER PLATE
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LOWER PLATE

Batch: *B34409*

mf

3.0	AN960C416L	WASHER
-----	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960C416L	Washer	<i>m104936</i>

mf 07-10-22

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469 Using Dt8849 Assembly Jig, Use 1/4" Shaft To Align Butterfly Shaft holes

2-Spot Weld as per Dwg D3469 and Dart QSI 018

mf 07-10-22 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/1/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:51:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 35111

Part Number: D3469043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9L

VISUAL WELDING INSPECTION

R



Comment: VISUAL WELDING INSPECTION

SB 07/10/122

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/22

①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location *GA*

SB 07/10/122

①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/10/123

①

Job Completion



12/07/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

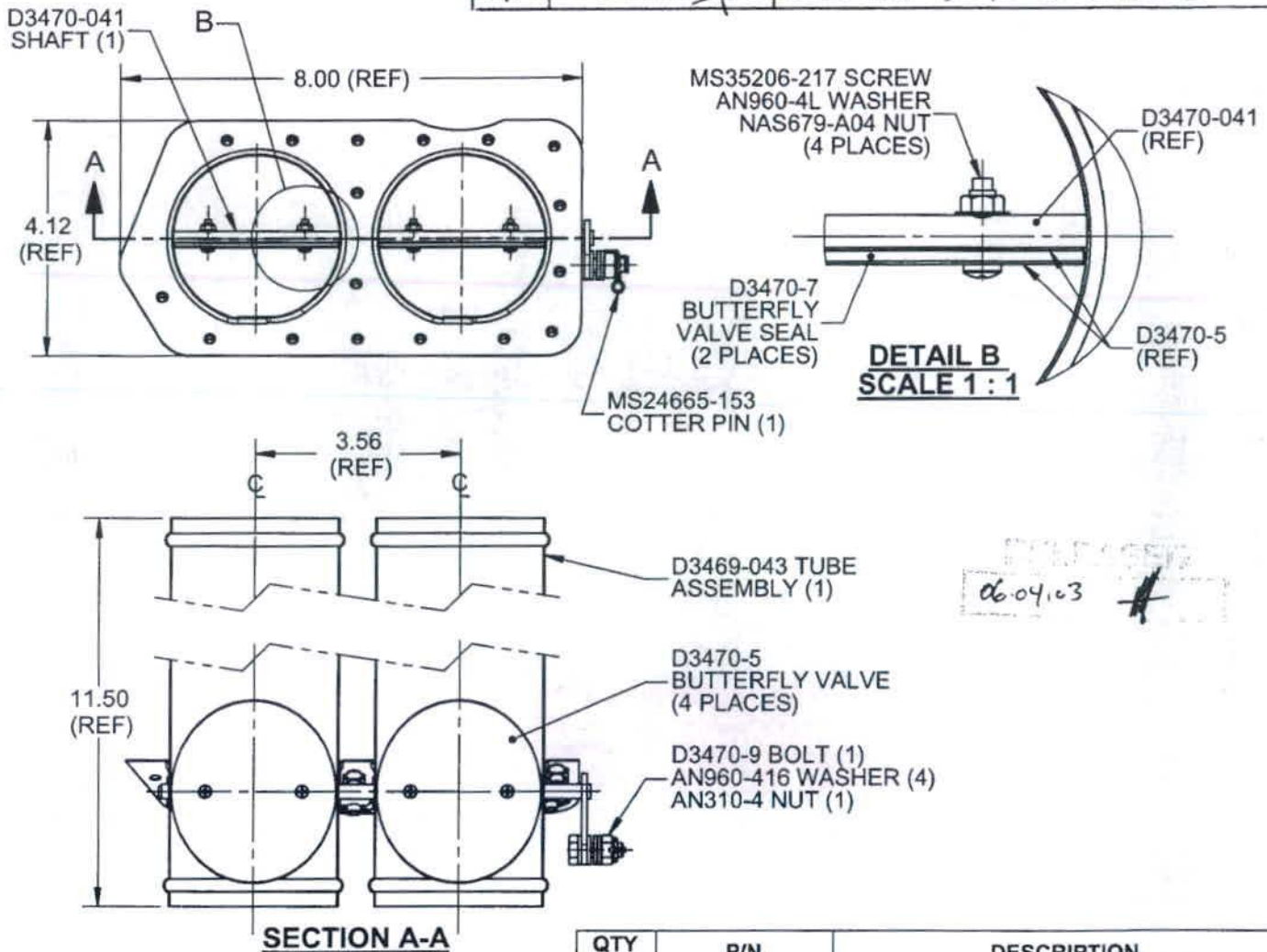
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED BOM on PAGE 2	



D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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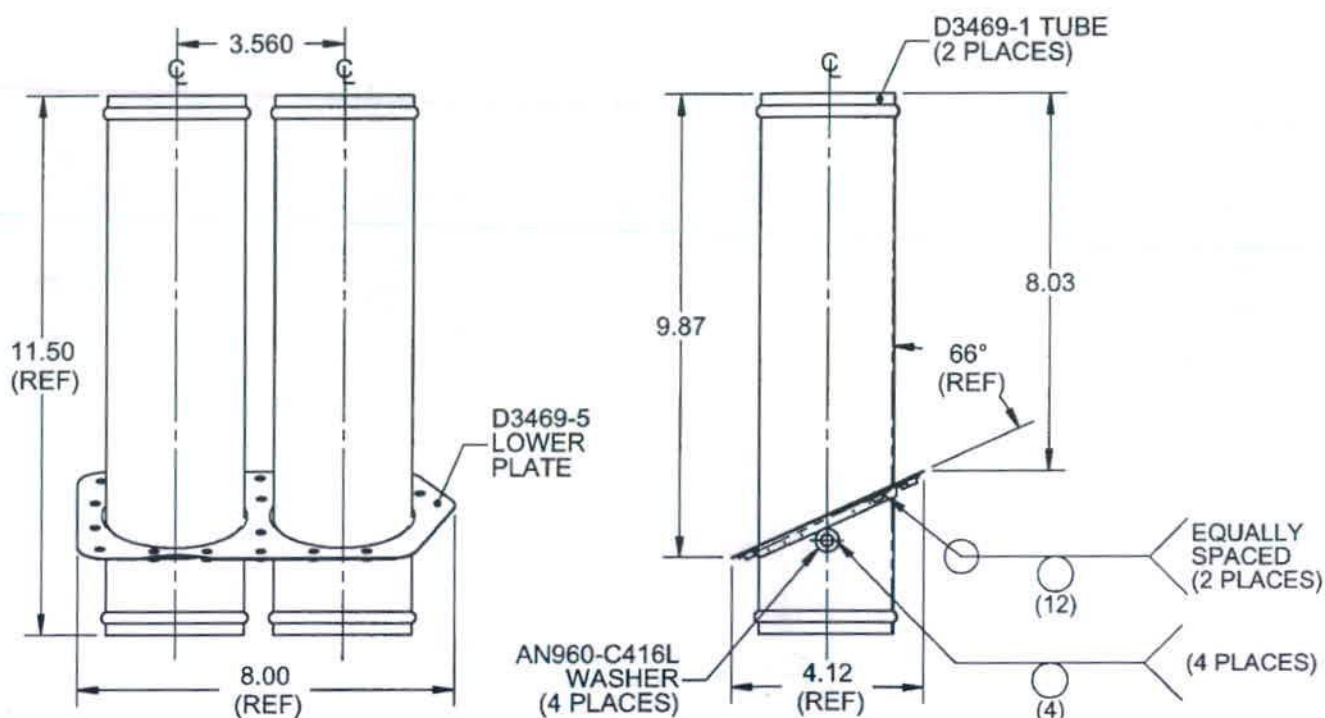
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

06-04.03



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D3469-043 TUBE ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

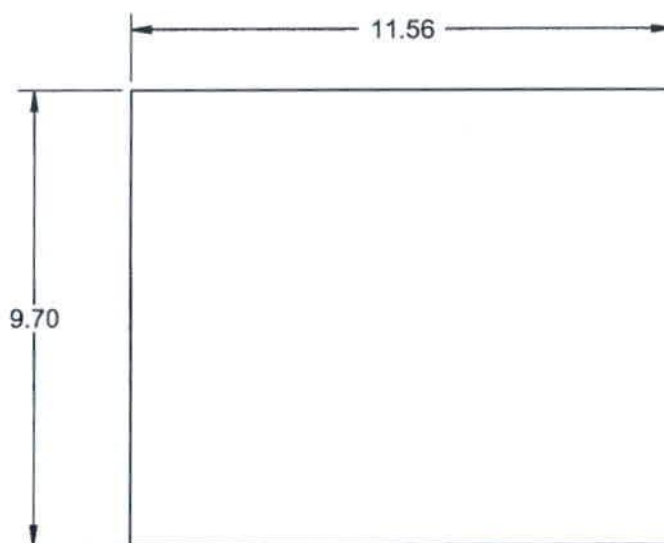
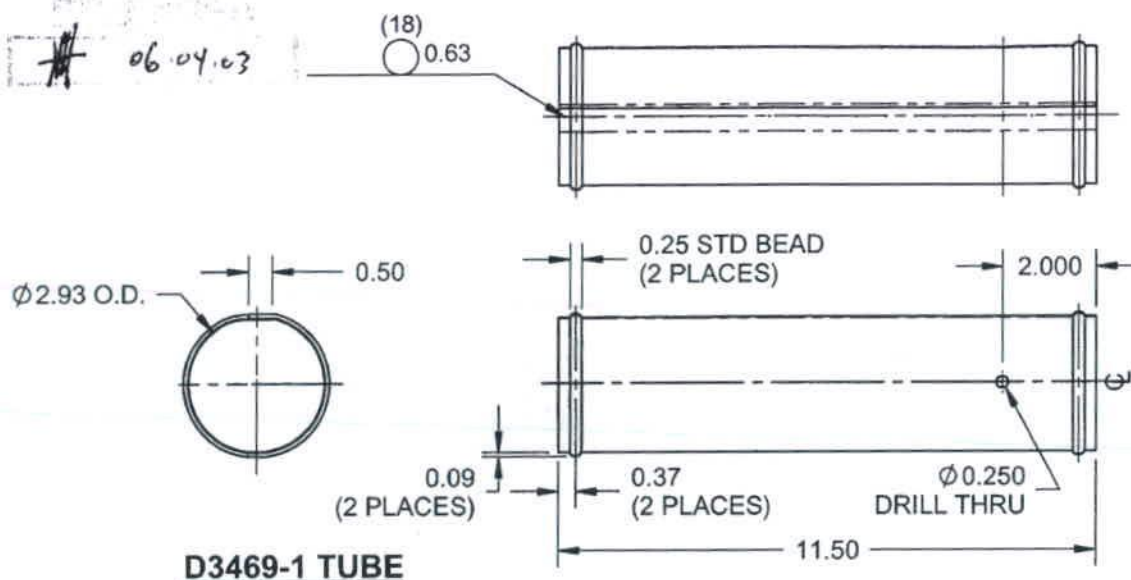
QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE
4	AN960-C416L	WASHER

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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

**D3469-1F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

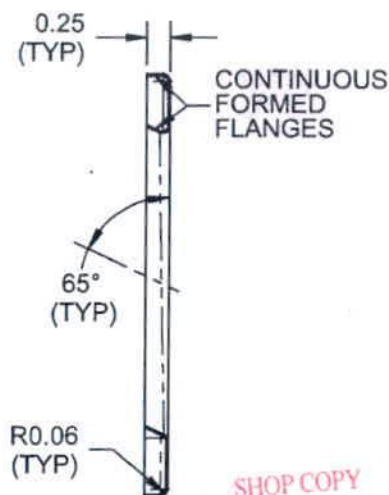
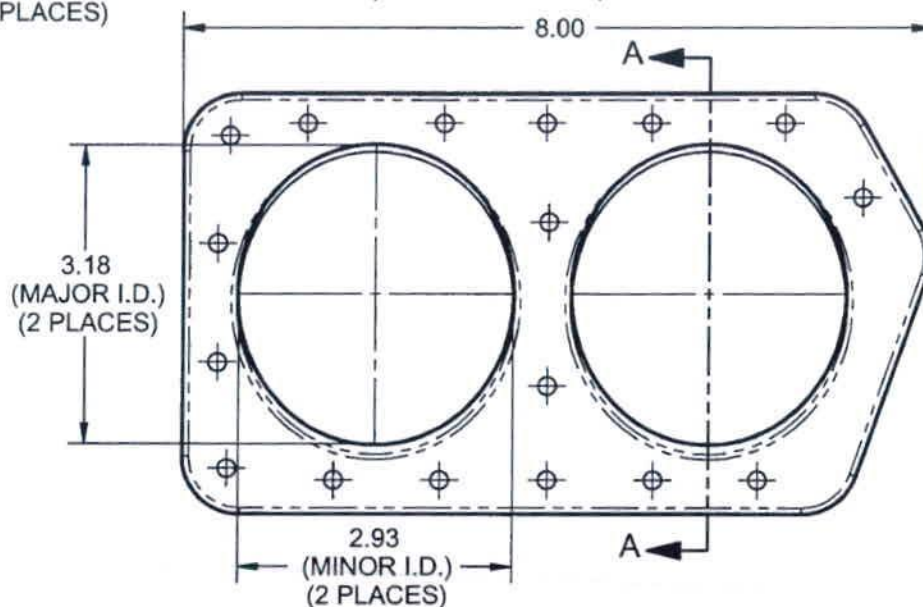
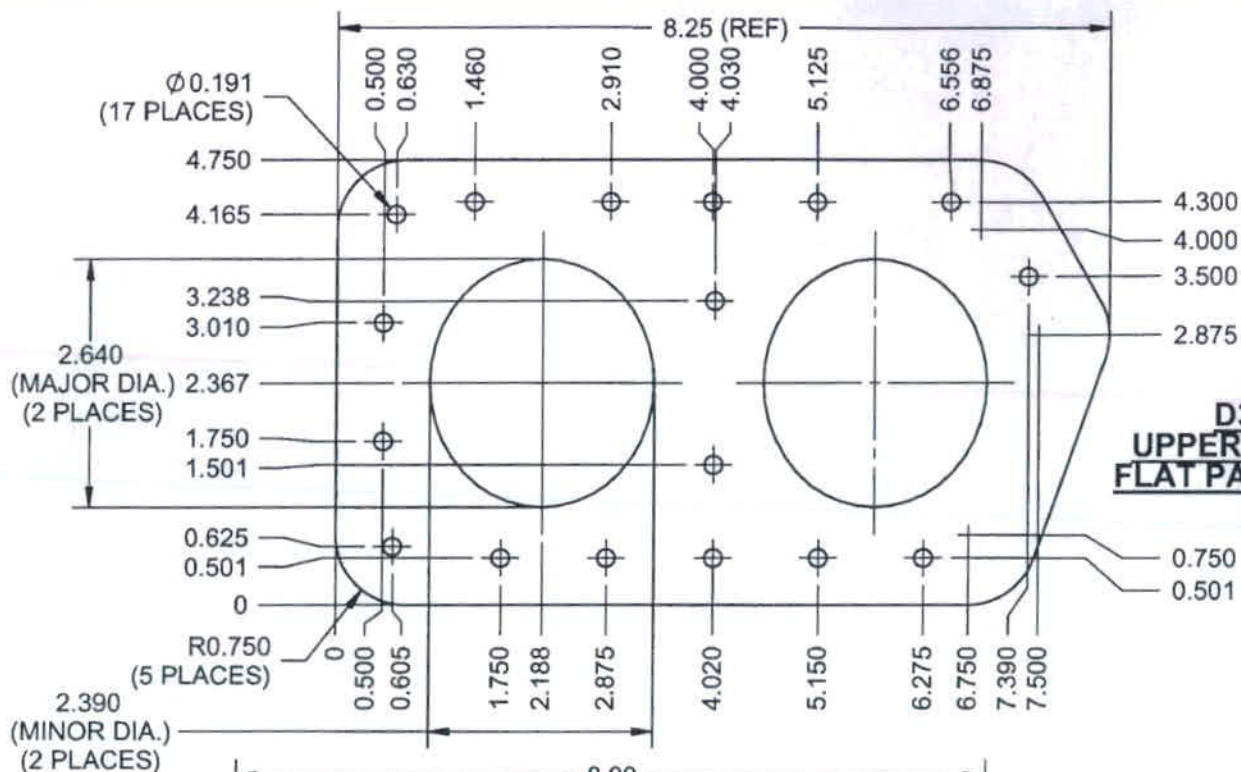
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 4 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



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D3469-3 UPPER PLATE BENDING DETAIL**NOTES:**

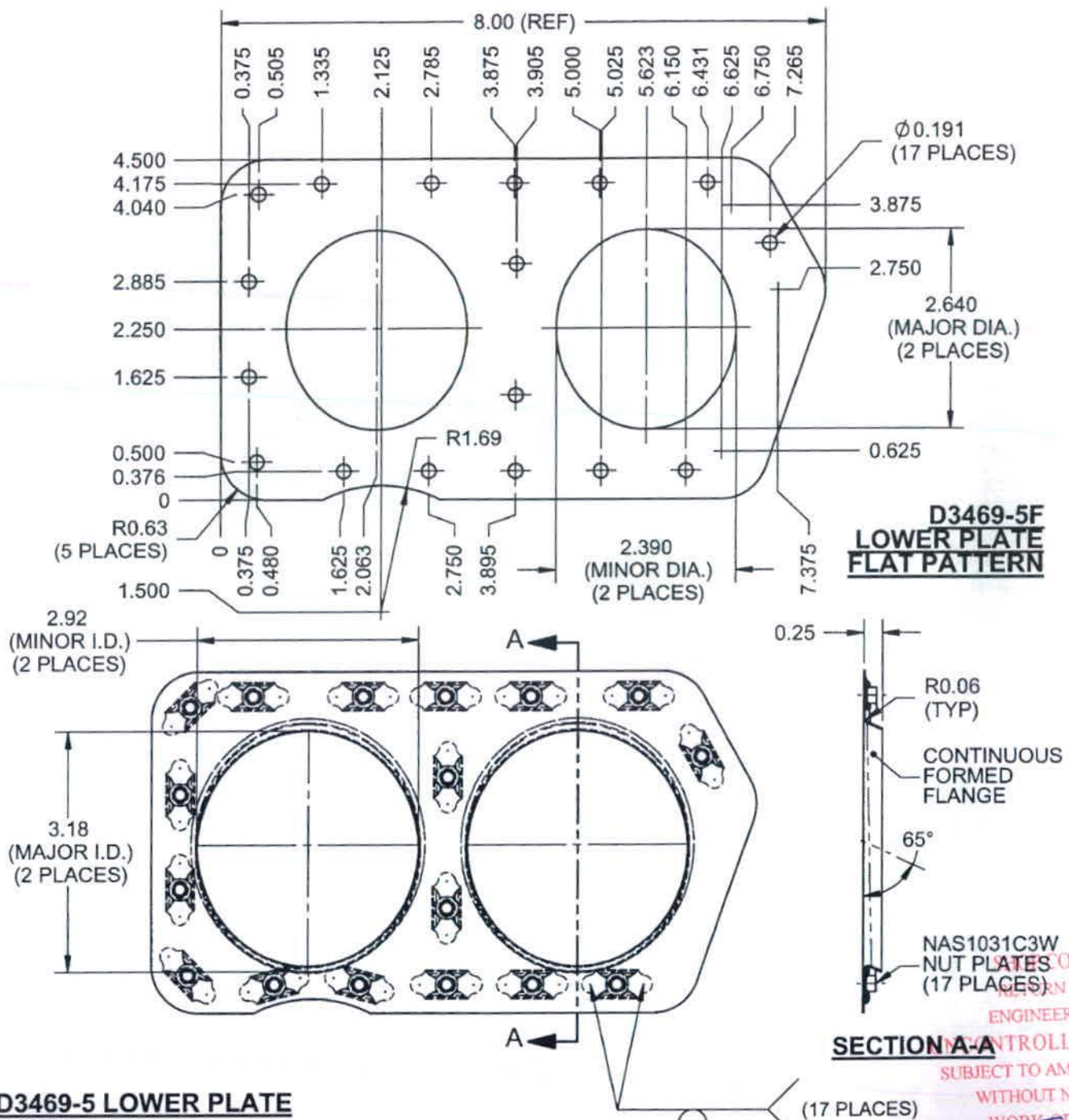
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:2

**D3469-5 LOWER PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 29

EMPLOYEE: Melanie Fautay

PART NUMBER: D3469-043

JOB NUMBER: 835111

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.15

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/08/22
QUALIFIER: SB

